

Work Order ID 124062***124062***

Page 1

Tuesday, September 09, 2014 9:18:49 AM

Item ID: D3119-042 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Cover Assembly
Start Date: 9/9/2014 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 9/26/2014 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: MF Date: 4-9-9 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3119	Rev B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 25702

Manufacture D3119-042 Cover Assembly as per Dwg D3119 (2x D3119-3 window)

Supplier: Delastek

Material: Cream Kydex 100, 0.060 thick

Material release note required

CL 14/10/09 (4)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

CL 14/11/18 4

Tuesday, September 09, 2014 9:18:47 AM

Page 1

124062

D3119-042

Required Date: 9/26/2014

Required Qty: 4.00

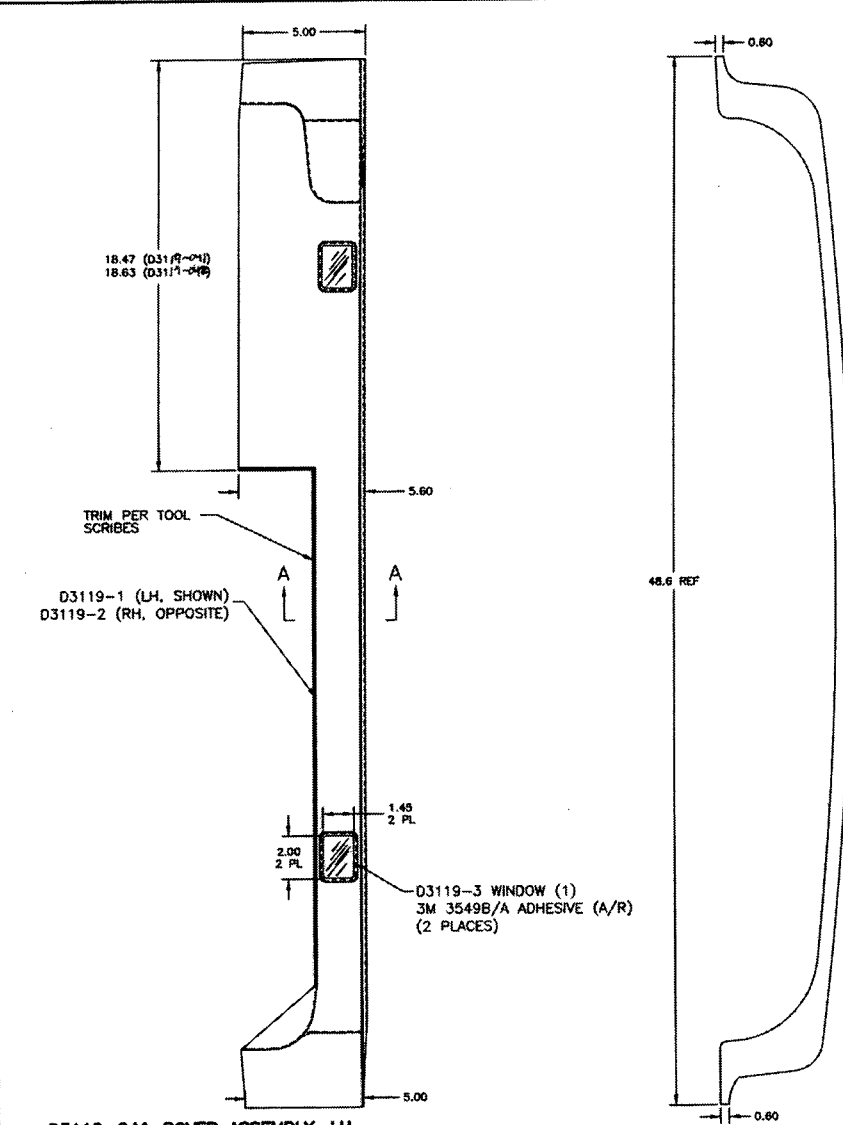
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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4

D3119-042P

02/14/11/18

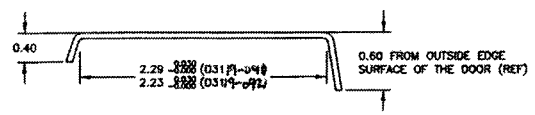
Cover Assembly



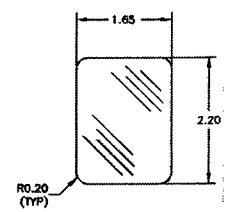
D3119-041 COVER ASSEMBLY, LH
(SHOWN, REPLACES PREMIER P/N B30-23000-29)
D3119-042 COVER ASSEMBLY, RH
(OPPOSITE, REPLACES PREMIER P/N B30-23000-30)

MY
124062

RELEASED
04-11-25



SECTION A-A



D3119-3 WINDOW

- D3119-1 COVER, LH (SHOWN, REPLACES PREMIER P/N B30-23000-219)**
1) MAKE FROM TOOL B30-23000-219T
2) MATERIAL: CREAM KYDEX 100, 0.060 THICK
- D3119-2 COVER, RH (OPPOSITE, REPLACES PREMIER P/N B30-23000-220)**
3) MAKE FROM TOOL B30-23000-220T
4) MATERIAL: CREAM KYDEX 100, 0.060 THICK
- D3119-3 WINDOW (REPLACES PREMIER P/N B30-23000-221)**
5) MATERIAL: LEXAN, 0.060 THICK

- GENERAL NOTES**
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) ALL DIMENSIONS ARE IN INCHES

B	04.11.17	RE-DESIGN
A	02.04.15	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3119
DATE	04.11.17	TITLE COVER ASSEMBLY
COPYRIGHT © 2002 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		REV. B SHEET 1 OF 1 SCALE NTS



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25702

Purchase Order Date 9/9/2014

PO Print Date 9/9/2014

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3119-042P AS PER DWG D3119 REV. B B124062	Cover Assembly	10/27/2014 Yes 10/27/2014		4.00 ✓ Each C214111/18	\$112.62	\$450.48
Line Total:							\$450.48
2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A041 quality management A042 dart noyification by supplier A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	10/27/2014 No 10/27/2014		1.00 ✓	\$0.00	\$0.00

Note:

9/9/2014

FACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25702

Purchase Order Date 9/9/2014

PO Print Date 9/9/2014

Page Number 2 of 2

Order From :

DELASTEK INC
2699 SE AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Total: \$0.00

PO Total: \$450.48

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 9/9/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	58799
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200


Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
17-11-2014	09-09-2014	24976	Chantal Lavoie	PO25702	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Melody Shapcott, ext. 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
4	0	4	DKC135-0002	Line #1 D3119-042 Cover Assy B124062 ✓ U of M: Chaque Dwg Rév.: B C214/11/18 Lot # 65366 ✓ 4 DOCUMENT INCLUS 	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: 

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2014-10-30 15:50:21
Utilisateur: Véronique Bouchard

Feuille de Procédé

ASAP

Client : DART US DART AEROSPACE
Numéro Job : 65366
Numéro : 4137
Numéro B.A. :
Cette fois : 2014-10-30 No. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 29238Nom Dessin : COVER ASSY
Numéro Article : DKC135-0002
Numéro Dessin : D3119
Projet Numéro : DKC135
Révision dessin : B
Matériel : Kydex 100 beige .060" Thk
Date Dûe : 2014-11-06 Qté: 6 Ud UNITEÉcrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Dart Aerospace: D3119-042
N° de pièce Delastek Aeronautique: DKA359-0006
N° de pièce Delastek Composites: DKC135-0002Process Sheet Rév.: 02 Modifier dimension du matériel
dans la séq. Thermoformage.

COPIE

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AMB0208 Kydex 100 cream 0.060"thick # 72005

Comment Qty.: 0.36 FEUILLE(s)/Unit Total : 2.16 FEUILLE(s)
Kydex 100 cream 0.060"thick N° de Lot : 4846010AA

2.0 THERMOFORMAGE Thermoformage / Découpe primaire



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Monter le set-up du moule de thermoformage N° DKG 359-505 sur le thermoformeur 4' x
8' selon IG 0088.

Tailler le matériel selon les dimensions requises : 24" x 68" x .060" Thk.

Thermoformer la pièce B30-23000-220 selon IG 0089.



Quantité : 6 Date : 31/10/14 Sceau :

3.0 TRIMAGE Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs














Faire la découpe primaire sur la scie à ruban.

Faire le trimage de la pièce selon la ligne tracée sur le moule (elle doit apparaître sur la
pièce) et selon le dessin page 21 (Pour les trous).

Ébavurer.

Date: Jeudi, 2014-10-30 15:50:21
Utilisateur: Véronique Bouchard

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	COVER ASSY
Numéro Job:	65366	Numéro	DKC135-0002
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
Quantité : <u>6</u> Date : <u>10-11-14</u> Sceau : 			
4.0	AMB0209	Lexan 9034 transparent 0.060" thickness	
Comment	Qty.: 0.000 POUCE CAR(s)/Unit Total: 0.000 POUCE CAR(s) Lexan 9034 0.060" thickness N° de Lot : <u>4844010 AA</u>		
5.0	TRIMAGE	Trimage	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Sur le banc de scie, tailler les B30-2300-221 selon les dimensions du dessins (1.65" x 2.20") et faire des rayons de .20" aux quatre coins. Ébavurer. Quantité : <u>6</u> Date : <u>11-11-14</u> Sceau : 		
6.0	AAC0562	3549 B/A adhesive kit 2oz.	
Comment	Qty.: 0.00 UNITE(s)/Unit Total: 0.00 UNITE(s) 3549 B/A adhesive kit 2oz. N° de Lot : <u>4844010 AA</u>		
7.0	PRÉPARATION.	Préparation du matériel	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs Faire le mélange de l'adhésif 3549 B/A selon les instructions inscrites sur le contenant. Date : <u>6</u> Sceau : <u>11-11-14</u> 		
8.0	ASSEMBLAGE	Assemblage mécanique	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Assembler les deux B30-23000-221 Window sur le B30-23000-220 à l'aide de l'adhésif 3549 B/A et laisser sécher pendant 16 heures. Quantité : <u>6</u> Date : <u>11-11-14</u> Sceau : 		
9.0	IDENTIFICATION	Identification des pièces	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'identification : N° de pièce : D3119-042 Date de fabrication : <u>14-11-14</u> N° de Work Order: _____ Sceau d'inspection		

Date: Jeudi, 2014-10-30 15:50:21

Utilisateur: Véronique Bouchard

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: COVER ASSY

Numéro Job: 65366

Numéro DKC135-0002

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité : 6 Date : 14-11-14 Sceau : 14



10.0

INSPECTION

Inspection générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité selon le dessin

Quantité : 6 Date : 14-11-14 Sceau : 14



11.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057.

Quantité : 6 Date : 14-11-14 Sceau : 14

